

Date: Wednesday, 3/12/2008 1:51:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BACK PANEL	
Job Number	37876		Part Number	D30231	
Estimate Number	11093		Drawing Number	D3023 REV A	
P.O. Number			Project Number	N/A	
This Issue	3/12/2008	S.O. No.	Drawing Revision	A	
Prsht Rev.	NC		Material		
First Issue	/ /		Due Date	4/11/2008	Qty: 1 Um: Each
Previous Run	36149				
Written By	<i>JF 08 03 12</i>				
Checked & Approved By					
Comment	Est.	02.01.23	Revised	NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet



Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)

2024-T3 .032 sheet

Material: 2024-T3 sheet (QQ-A-250/4) 0.032"

Batch: *109240 HB 8-10-30*

2.0	LARGE FAB 1	A flow SET A HB 8-10-30	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

*1 Trace and Cut Out Panel Using DT8621 Jig  
Done at water Sch**2 Drill Using DT8621**3 Deburr**HB 8-10-30*

4-Form as per dwg D3023

(1)

(1)

08/11/03

08/11/04

SB

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M-1**08/11/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:51:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 37876

Part Number: D30231

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 POWDER COATING

POWDER COATING



M 106442



(1X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 08/11/06

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



g/f



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-07 (X)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP42416

88 08/11/06 (1)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06 (f)

Job Completion



MF 08-11-10

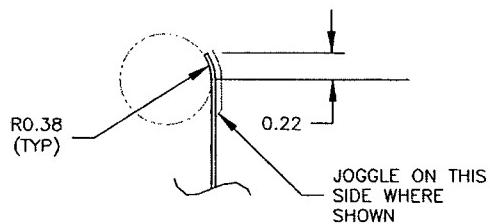
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

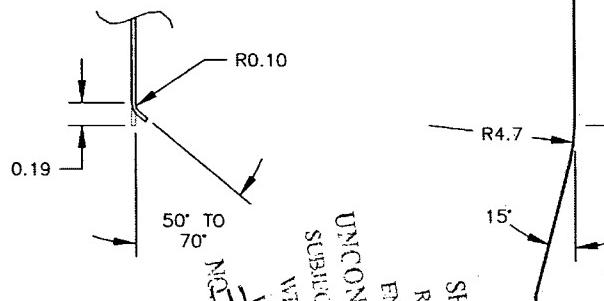
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**SECTION A-A**  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)



**SECTION B-B**  
SCALE 1:1  
(BOTTOM EDGE ONLY)



**RELEASED**  
9.06.07

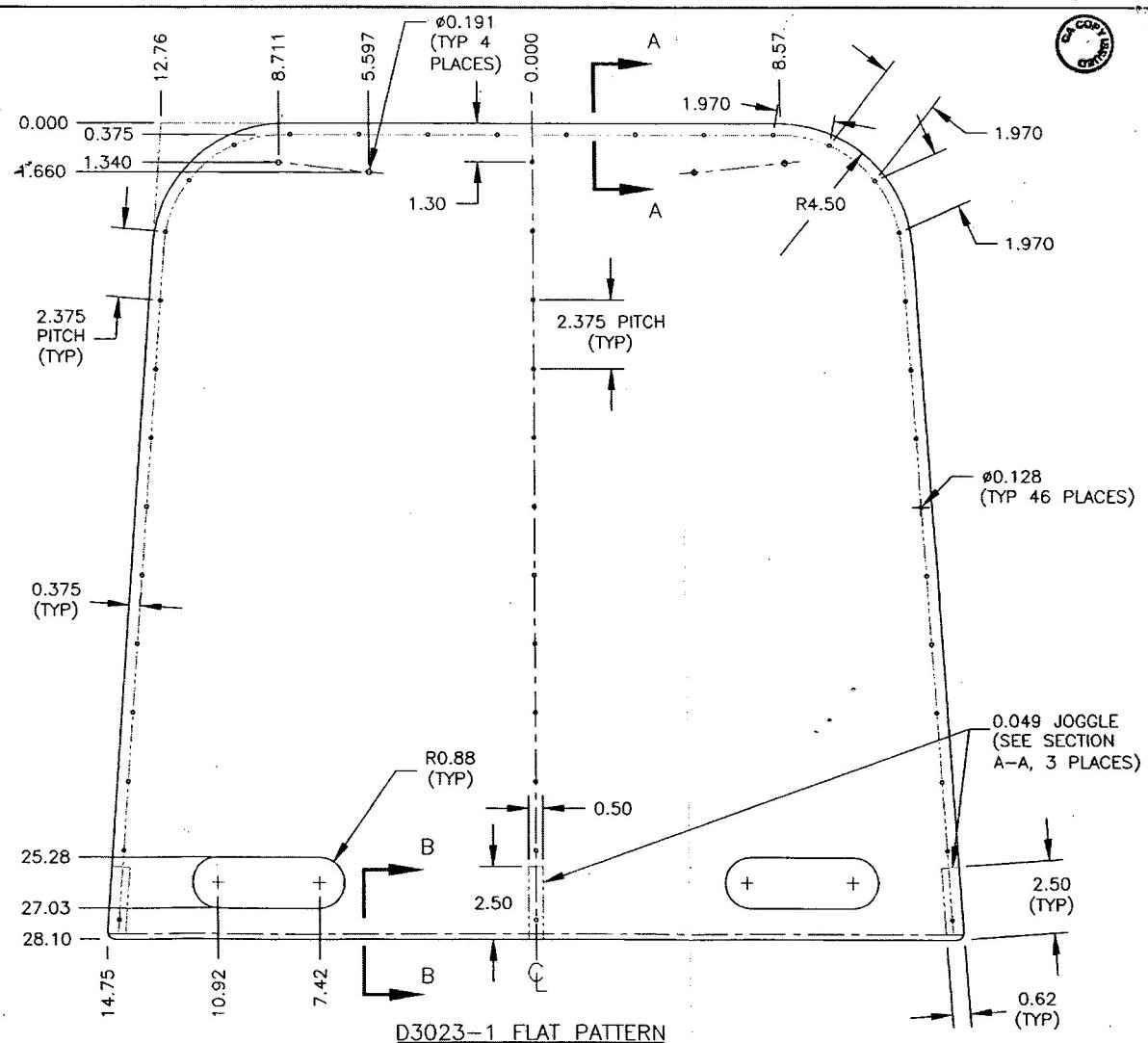
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 37876

ENGINEERING  
RETENTION  
TO  
SHOP COPY

D3023-1 BEND DETAIL

**D3023-1 BACK PANEL:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032" THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART-QSI 005 4.1  
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	H	APPROVED H
		DART
		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
		REV. A
		DRAWING NO. D3023
		SHEET 1 OF 1
DATE	01.05.18	TITLE BACK PANEL
		SCALE
		1:1

**DART AEROSPACE LTD**

**Work Order:** 37876

Description: BACK PANEL

**Part Number:** D3023-1

Inspection Dwg: D3033-1, Rev: A

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Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **X First Article      X Prototype**

**Measured by:**

15

**Audited by:**

### **Prototype Approval:**

1

Date:

9-15-31

Date: 09/10/30

**Date:**

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	